

Work Order ID 68505

Thursday, April 14, 2011 10:20:42 AM



Page 1

Item ID: D3538-1

Revision ID:

Item Name: Hinge Bracket

Start Date: 4/14/2011 Start Qty: 10.00

Required Date: 4/27/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: CL

Date: 4/14/11

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3538

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

SL 11/04/26

(10)

φ

Jeaspa Bandsaw

Cut blanks 1.500" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

SL 11/05/03

(10)

φ

HAAS CNC vertical machine #1

1-Machine as per Folio FA651 and Dwg D3538□2-Deburr

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

SL 11/05/03

10

φ

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68505

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Page 2

Item ID: D3538-1

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Start Date: 4/14/2011 Start Qty: 10.00

Required Date: 4/27/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

G.A 11/05/04

10

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10

0

JH 11/05/04

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

10:10

START TIME:

OVEN TEMPERATURE:

320 01 FINISH TIME:

10:40

10

0

M-L 11/05/04

M 116964

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68505

Thursday, April 14, 2011 10:20:42 AM



Page 3

Item ID: D3538-1

Revision ID:

Item Name: Hinge Bracket

Start Date: 4/14/2011 Start Qty: 10.00

Required Date: 4/27/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 4 14 11/05/11

170

Identify as per dwg & Stock Location: 64

0.00



Packaging

Memo

0.00

Packaging

11/05/11 100

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 8

11/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:20:39 AM

Page 1

Work Order ID: 68505

Parent Item: D3538-1

Parent Item Name: Hinge Bracket

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-10.03 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	6.5000	0.19	2			



6061-T6 Bar 1.25 x 1.25



2 11/04/26

Location

Loc Qty

Loc Code

MAT003

6.5

116135

6.5

2.0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

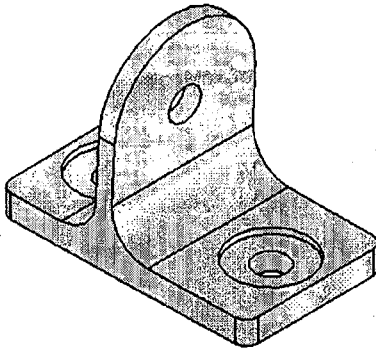
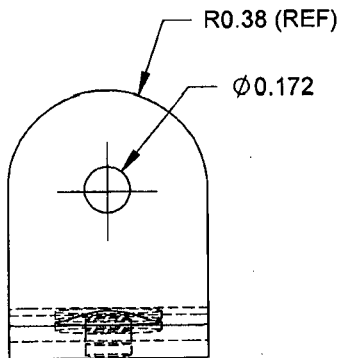
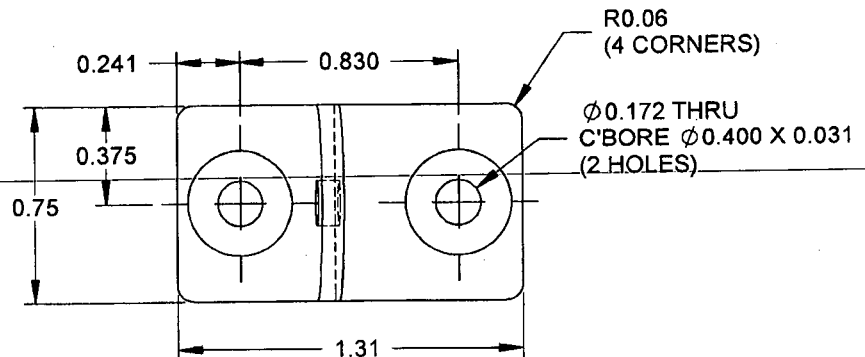
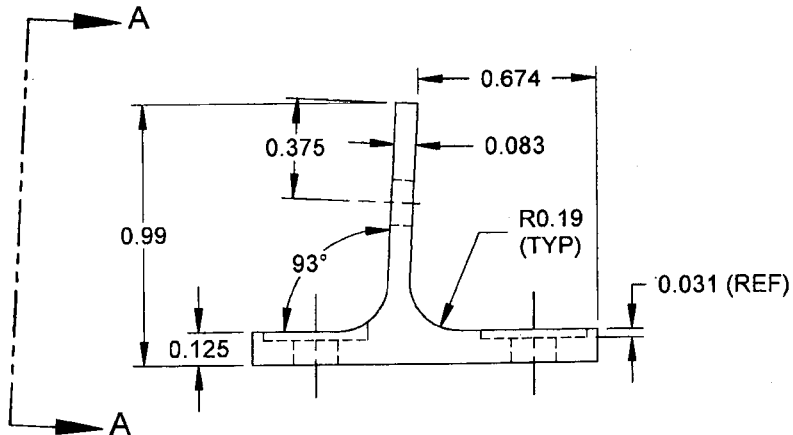
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

**RELEASED**
06.10.13**AUXILIARY VIEW A****D3538-1 HINGE BRACKET**

CL11104/14
W10, 68505

NOTES:

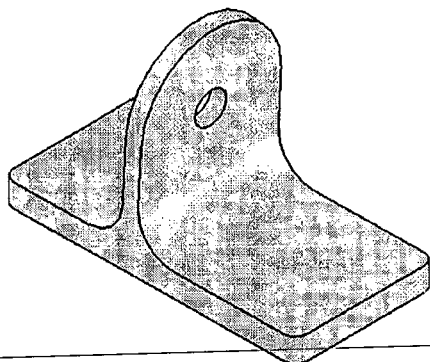
- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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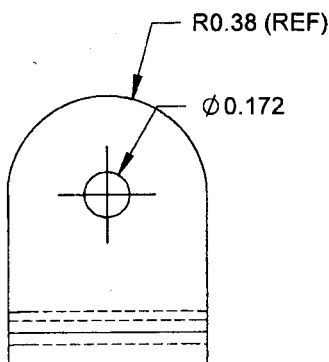
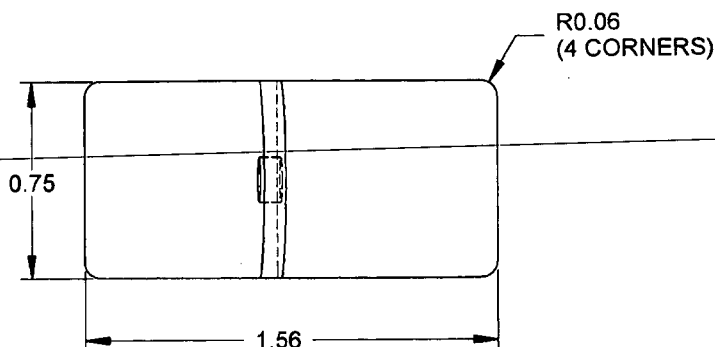
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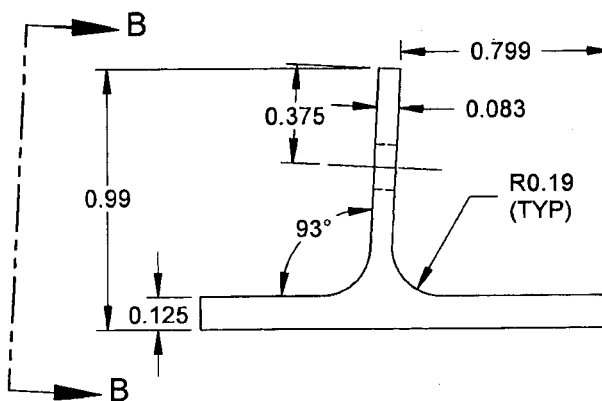
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1



RELEASED
06.10.13



AUXILIARY VIEW B



D3538-3 HINGE BRACKET

Q10: 68505

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order:	68505
Description: Hinge Bracket		Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.750	/		Pen-V-3	
0.375	+/-0.010	0.375	/			
0.241	+/-0.010	0.243	/			
0.830	+/-0.010	0.836	/			
Ø0.172	+0.005/-0.001	0.173	/			
Ø0.400	+0.006/-0.001	0.400	/			
0.031	+/-0.010	0.027	/			
1.31	+/-0.030	1.312	/			
0.375	+/-0.010	0.375	/			
0.99	+/-0.030	0.988	/			
0.125	+/-0.010	0.124	/			
R0.19	+/-0.030	0.19	/			
0.083	+/-0.010	0.085	/			
93°	+/-0.5°	93°	/			
0.674	+/-0.010	0.673	/			
R0.38	+/-0.030	0.375	/			
Ø0.172	+0.005/-0.001	0.173	/			

Measured by: SL	Audited by: B.A	Prototype Approval:	N/A
Date: 11/05/04	Date: 11/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	